

# Work Order ID 69857

Friday, May 20, 2011 10:40:38 AM



Page 1

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, LH

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/05/20 Tooling:    Date:     
QC:    Date:    SPC (Y/N):    Date:   

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	DUR								
100		0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank 7.625" long								
110		0.00							
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg & Folio FA880 Dwg Rev: <u>F</u> Folio Rev: <u>AA</u>								
	Deburr								

ant 11/06/07

2

SL 11/06/08

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries

**Work Order ID 69857**

Friday, May 20, 2011 10:40:38 AM



Page 2

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, LH

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/06/08

2

φ

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

B.A 11/06/08

2

φ

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

2x φ m-11/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* NOTE: Date & initial all entries

# Work Order ID 69857

Friday, May 20, 2011 10:40:38 AM



Page 3

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, LH

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
160  Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i>  Memo <i>W/069855</i>	0.00  0.00							
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

*2 0 11 06 10 09*

*EP 11/06/09 @*

*11/6/9*

*ME*  
*11-06-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* NOTE: Date & initial all entries

# Picklist Print

Page 1

Friday, May 20, 2011 10:40:35 AM

Work Order ID: 69857

Parent Item: D4038-3

Parent Item Name: Angle, Aft, LH



Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: lpp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	21.2845	0.7	1.473684			



6061T6 ANGLE 4.00 x 4.00 x .250

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT006	20	
117285	20	
MAT007	1.2845	
114507	1.2845	

1.473 *am 6/10/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 69857
Description: Angle, A7, LH		Part Number: D4038-3
Inspection Dwg: D4038, Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+-.030	3.996	/		Vern JL-3	
1.25	+-.030	1.249	/			
4.00	+-.030	3.995	/			
1.25	+-.030	1.245	/			
.250	+-.010	.246	/			
1.250	+-.030	.250	/			
2.904	+-.010	2.904	/		H-G	
.581	+-.010	.581	/			
.669	+-.010	.669	/		H-G	
.735	+-.010	.735	/		H-G	
.500	+-.010	.500	/			
2.00	+-.030	2.010	/			
.500	+-.010	.500	/		H-G	
Ø.316	+-.006 -+.001	.316	/			
Ø.189	+-.005 -+.001	.190	/			
.13	+-.030	.130	/			
.70	+-.030	.700	/			
1.000	+-.010	1.000	/		H-G	
1.500	+-.010	1.500	/			
.50	+-.030	.500	/			
7.50	+-.030	7.500	/		Vern CMC-02	
1.750	+-.010	1.750	/			
1.270	+-.010	1.267	/			

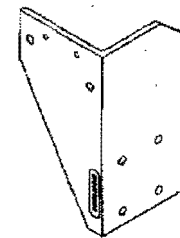
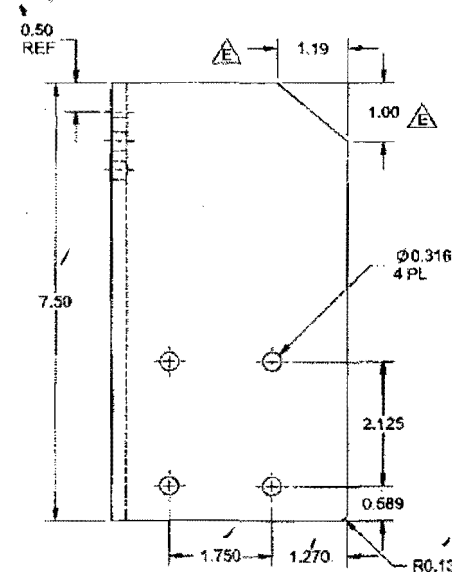
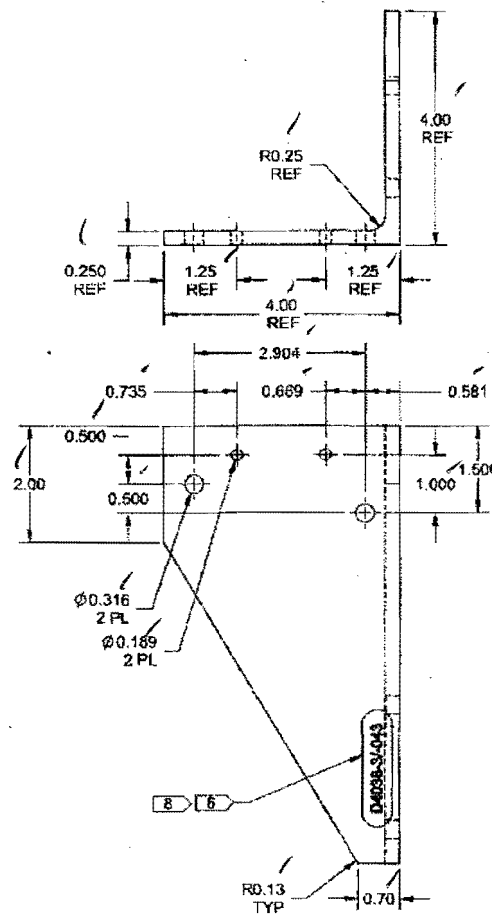
Measured by: JL	Audited by: KA	Prototype Approval:
Date: 11/06/08	Date: 11/06/08	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	









69857

RELEASED  
2011-04-21  
JAN

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX  
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.18 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

D4038-3 ANGLE, AFT, LH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAMMERSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 6 OF 14
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
DATE	11.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DRAWING IS UNCLASSIFIED AND CONTROLLED UNDER THE CANADIAN PATENT ACT AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

158  
095

